



Dart Aerospace Ltd.
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D4931-5**Job Sheet 201966****Part No:** D4931-5**Job Qty:** 12 pcs**Part Name:** Engine Fitting (for B3e models)**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 10/17/19**Job Tracking No:****Due Date:** 11/8/19**Created By:** Marie Lajeunesse**Type:** SOLD**Description:****Note:** DWG REV A SHEET 3 IPP REV:A NEW ISSUE 13-09-16 JLM VERIFIED BY:DD**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Doosan - 1	12 pcs		11/8/19	1.00	10.43	Doosan - 1		<i>De</i>
110	QC 2	12 pcs		11/8/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		



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Container No: S229118**Part:** D4931-5**Job No:** 201966**Serial No/Batch:** S229118**Revision:****Inspector:****Exp Date:****Instructions:** Various STC's**Date:** 11/02/19

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						QC 2 - 65	
						QC 2 - 5	
						QC 2 - 71	
						QC 2 - 73	
						QC 2 - 69	
112	Conventional Mill - 1 - B4B	12 pcs	11/8/19	0.00	4.96	Conventional Mill - 1 - B4B	19/11/14
						Conventional Mill - 2 - B4B	
115	QC 2	12 pcs	11/8/19	0.00	0.00	QC 2 - 1	
						QC 2 - 12	
						QC 2 - 14	
						QC 2 - 17	
						QC 2 - 19	
						QC 2 - 2	
						QC 2 - 20	
						QC 2 - 22	
						QC 2 - 23	
						QC 2 - 25	
						QC 2 - 32	
						QC 2 - 33	
						QC 2 - 35	
						QC 2 - 39	
						QC 2 - 4	
						QC 2 - 40	
						QC 2 - 44	
						QC 2 - 45	
						QC 2 - 48	
						QC 2 - 49	
						QC 2 - 50	
						QC 2 - 51	
						QC 2 - 52	
						QC 2 - 57	
						QC 2 - 62	
						QC 2 - 63	19/11/14
						QC 2 - 8	
						QC 2 - 66	
						QC 2 - 64	
						QC 2 - 65	
						QC 2 - 5	
						QC 2 - 71	
						QC 2 - 73	
						QC 2 - 69	
120	QC 8	12 pcs	11/8/19	0.00	0.00	QC 8 - 12	19/11/14
						QC 8 - 14	
						QC 8 - 17	
						QC 8 - 20	
						QC 8 - 25	
						QC 8 - 3	
						QC 8 - 32	
						QC 8 - 33	
						QC 8 - 35	
						QC 8 - 39	
						QC 8 - 4	
						QC 8 - 44	
						QC 8 - 45	
						QC 8 - 49	
						QC 8 - 58	
						QC 8 - 8	

					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
					QC 8 - 61	
130	Packaging 3-2 - Stock - B4B	12 pcs ✓	11/8/19	0.00 0.00	Packaging 3 - 1 - B4B	
Oscar NOV 11 2019					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B ✓	ST 127
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
140	QC 21 - SA	12 pcs ✓	11/8/19	0.00 0.00	QC 21 - SA - 21 ✓	ST 127
					QC 21 - SA - 70	DAS 21
					QC 21 - SA - 53	9-09
Part Op 100 - (Doosan Lathe) Machine as per folio FB210 Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB) 112 - (Manufacture as per dwg) DRILL HOLES AS PER REQUIRED 115 - QC2- Inspect parts off machine FAI/FAIB) 120 - QC8- Inspect parts - second check) 130 - Identify as per dwg & Stock Location: _____) 140 - (QC21- Final Inspection - Work Order Release)						

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M303R2.000	303 Round Bar 2"	1.8000 ft (.15 ea)	100-Doosan - 1	S22/909 3,667
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Doosan - 1	M303R2.000	2	13	0
Part Specifications				
Specifications could not be found.				

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DART AEROSPACE LTD		Work Order:	201966
Description: EAPS P2 Engine Fitting		Part Number:	D4931-5
Inspection Dwg: D4931	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1-1/16-12 UN 2A	N/A	1-1/16-12	✓		Wire cut and dist ref	
37°	+/-0.5°	37°	✓		Pro	
0.185	+/-0.010	.185	✓		Caliper	
0.315	+/-0.010	.310	✓			
0.424	+/-0.010	.430	✓			
0.250	+/-0.010	.248	✓			
0.938	+/-0.010	.938	✓			
1.927 Ref	+/-0.010	1.928	✓			
0.25	+/-0.030	.249	✓			
0.13	+/-0.030	.1305	✓			
0.907	+/-0.010	.904	✓			
0.078	+/-0.010	.080	✓			
Ø0.063	+0.004/-0.001	.066	✓			
0.13 x 45°	+/-0.030 x +/-0.5°	1/8 x 45°	✓			
0.34	+/-0.030	.345	✓			
0.25	+/-0.030	.245	✓		Caliper	
Ø0.238	+0.005/-0.001	0.239	✓		Verifier JVD	
35°	+/-0.5°	35°	✓		"	
0.532	+/-0.010	0.531	✓		Caliper	
1.063	+/-0.010	1.061	✓		Verifier JVD	
0.513	+/-0.010	0.513	✓		Caliper	
0.749	+/-0.010	.748	✓		Verifier JVD	
1.025	+/-0.010	1.025	✓			

Measured by: [Signature]	Audited by: [Signature]	Preliminary Approval:
Date: 19/11/04	Date: 19/11/04	Date:

Rev	Date	Change	Revised by	Approved
A	14.06.24	New Issue	KJ	[Signature]



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

NCR No. _____

DISPOSITION		DEPARTMENT/PROCESS			
Job: _____	Rework ☐ Scrap ☐ Use-as-is ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) Prod. Eng. Coord. Rec/Store/Packaging	Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐	
Part No. _____					
Date: _____	Sequence #: _____	QTY Affected: _____			
Description Work Order Deviation		Disposition			
		Completed By			
		Lead hand / Supervisor			
		QC / QA Coordinator			
		MRB (QS042)			
Root Cause		FAULT CATEGORY			
Operator ☐	Pressure/Forced ☐	Contamination ☐	Power Loss/Surge ☐	Positioned Wrong ☐	
Manufacturing Process ☐	Bending ☐	Misaligned/off center ☐	Folio/Program ☐	Outside Tolerance ☐	
Equip/Tooling ☐	Crushing ☐	BOM/Route ☐	Grain Direction ☐	Drawing ☐	
Handling/Preservation ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Finish ☐	
Material ☐	Crimp/Kink/Ripple/Wave/Twist ☐	Incomplete/Unclear Instructions ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	
Product Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Out of Sequence ☐	Misread ☐	
Process Improvement ☐	Mislabeled ☐	Fit/Function ☐	Off-set/Set-up ☐		
Human Factors ☐	Other/Details: _____				